

Work Order ID 162307

Thursday, June 01, 2017 11:57:35 AM

7 June
162307

Page 1

Item ID: D350-740-011

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Aircraft Disabling Device

Start Date: 6/2/2017 Start Qty: 1.00

1

Cust Item ID:

Required Date: 6/6/2017 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: *PA*

DAS
21
9-89

Date: *20170601*

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

N/A

Rev N/A

JUN 02 2017

DAS
6
9-89

100

Document Control

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile and create labels per PPP D350-740-011 CHG002

2 DAS
28
9-89

JUN 06 2017

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

U DAS
6
9-89

JUN 02 2017

DAS
27
9-89

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.03

Quality Control

Ensure that keys can be locked and unlocked for each D3371-041 and D3372-041 assembly.

2 DAS
28
9-89

JUN 02 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
OTHER : ☐									

Work Order ID 162307***162307***

Page 2

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N900040100

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Start Date: 6/2/2017 Start Qty: 1.00

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Cust Item ID:

Required Date: 6/6/2017 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: Fg125
Packaging

0.00

130

Packaging

Memo

0.00

PACKAGING RESOURCE #1 Identify and pack for shipping as
per PPP D350-740-011 Location: Fg125 PPP
Rev: _____ Record Key Numbers For The Following: D3371-
041 D3372-041 _____2DAS
28
2 28JUN 02 2017

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.10

Quality Control

17/6/7 JAJUN 05 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
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Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
OTHER : ☐									

Picklist Print

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Page 1

Work Order ID: 162307

162307

Parent Item: D350-740-011

D350-740-011

Parent Item Name: Aircraft Disabling Device

Start Date: 6/2/2017

Required Date: 6/6/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:E Re-Format 06-01-13 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3371-041

Manufactured No

120

Each

4.0000

1

1

D3371-041

Tail Rotor Pedal Lock

**

Location

Loc Qty

Loc Code

ST498

4

148598

1

150926

1

154557

2

D3372-041

Manufactured No

110

Each

2.0000

1

1

D3372-041

Collective Lock AS350

**

Location

Loc Qty

Loc Code

ST499

2

150907

1

154234

1

DAS 27
9-89
JUN 02 2017

DAS 27
9-89
JUN 02 2017

DAS 28
9-89

DAS 28
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Misidentified ☐	Past Due ☐																																																																

- 3.3.3 Place the D3384-043 Collective Sock over the collective control stick as shown in Figure 2.
- 3.3.4 Unlock/open the collective lock and secure around the aircraft collective control base by aligning the shaft of the lock device with the hole in the collective base as shown in Figure 2. Engage cam and lock D3372-051/ D3400-051 Collective Lock Assembly with the provided key. Ensure that the device is locked and will not open.

3.4 D3372-041/ D3400-041 COLLECTIVE DISABLING KIT REMOVAL

- 3.4.1 Unlock D3372-051/ D3400-051 Collective Lock Assembly from the collective control base using the provided key. Open the lock, and remove from the collective control base.
- 3.4.2 Remove D3384-043 Collective Sock from the collective control stick.

4.0 PARTS LIST

-011	-013	Part Number	Description
X		D350-740-011	DUAL DISABLING KIT
	X	D355-740-013	DUAL DISABLING KIT
1	1	D3371-041	TAIL ROTOR PEDAL DISABLING KIT
1	1	D3371-051	* PEDAL LOCK ASSEMBLY
1	1	D3384-045	* CYCLIC SOCK
1	1	HX-81	* 1/4" -20 SOCKET HEAD CAP SCREW
2	2	AN960-416	* WASHER
1	1	D3373-7K	*** KEY, REPLACEMENT
1		D3372-041	COLLECTIVE DISABLING KIT
1		D3372-051	* COLLECTIVE LOCK ASSEMBLY
1		D3384-043	** COLLECTIVE SOCK
1		HX-81	** 1/4" -20 SOCKET HEAD CAP SCREW
2		AN960-416	** WASHER
1		D3373-1K	*** KEY, REPLACEMENT
	1	D3400-041	COLLECTIVE DISABLING KIT
	1	D3400-051	* COLLECTIVE LOCK ASSEMBLY
	1	D3384-043	** COLLECTIVE SOCK
	1	HX-81	** 1/4" -20 SOCKET HEAD CAP SCREW
	2	AN960-416	** WASHER
	1	D3373-1K	*** KEY, REPLACEMENT

* shown for reference only, part is included in D3371-041 assembly above

** shown for reference only, part is included in D3372-041/ D3400-041 assembly above

*** shown for reference only, p/n for ordering replacement keys

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Item ID: D350-740-011

Accept

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Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Aircraft Disabling Device

Start Date: 6/2/2017 Start Qty: 1.00

1

Cust Item ID:

Required Date: 6/6/2017 Req'd Qty: 1.00

1

Customer:

Reference:

Run Start

NR1

Approvals:

Process Plan:

Date:

20170601

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
N/A	Rev N/A								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile and create labels per PPP D350-740-011 CHG002								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.03							
Quality Control	Ensure that keys can be locked and unlocked for each D3371-041 and D3372-041 assembly.								

420A
JUN 02 2017

CB 2 JUN 05 2017